

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002447**Date Inspected:** 24-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

CWI Inspector: Mr. An Qing Xiang

Orthotropic Box Girder (OBG) and Tower Fabrication:

Bay 1

The QA Inspector performed ultrasonic inspections of four floor beam complete joint penetration groove welds: FB010-003-023 and FB009-007-021 both have class "A" indications. Welds FB010-008-023 and FB016-012-021 both appear to comply with project specifications. These welds had been previously accepted by ZPMC QC personnel. See the TL-6027 "Ultrasonic Test Report" dated today and the photograph below for additional information. The QA Inspector informed Lu Jian Hua that weld SP 529-001-064 appears to have a class "A" ultrasonic indication.

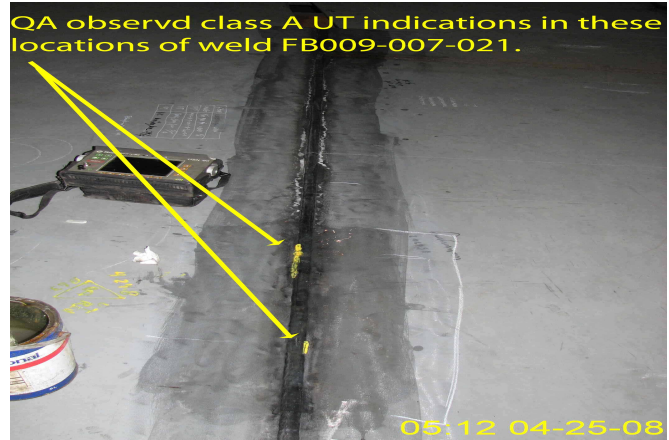
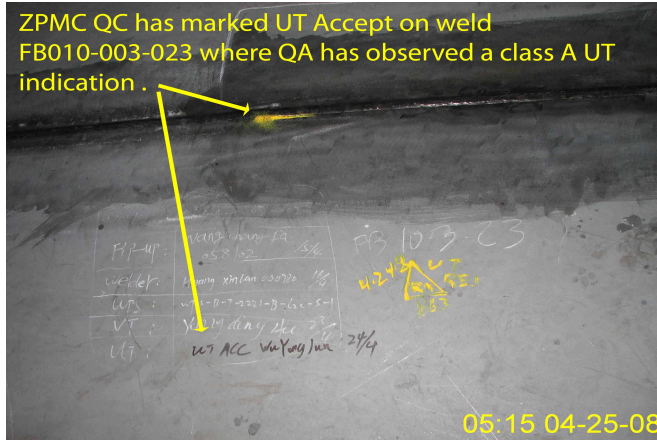
New tower shop

The QA Inspector observed ZPMC welder Mr. Xia Yong Liu stencil 48882 is using welding procedure

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

specification WPS-B-T-2221-B-L3C-S to make submerged arc groove weld SDI-SA216 A/K-18B. The QA Inspector observed a welding current of approximately 526 amps, 30.0 volts, a travel speed of 467 mm per hour, and the base material appears to be between 110°C and 230°C. Items observed by the QA Inspector appear to comply with project specifications.



Summary of Conversations:

See above for summary of conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
